

Date: Thursday, 31/07/2008 12:17:55 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STRUT
<b>Job Number</b> : 40845	
<b>Estimate Number</b> : 10275	
<b>P.O. Number</b> :	<b>Part Number</b> : D2565103
<b>This Issue</b> : 31/07/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2565 REV E
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : E
<b>Previous Run</b> : 38028	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 08/08/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 08.8.01</u>	
<b>Comment</b> : Est: F02.04.16 Added dwg Rev.C1 NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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**Comment:** Qty.: 1.5934 f(s)/Unit Total : 15.9338 f(s)

304 RD TUBE .750 X.49W

304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall

(M304TR0750W049)

Batch M 108 846SB 07/08/27

(10)

2.0	BRAKE NC	NC BRAKE
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**Comment:** BRAKE NC

Punch to length as per Dwg D2565 using DT8313

SB 07/08/27

(10)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole open to .316 Ø as per Dwg D2565 (one end only)

2-Deburr

F 08/08/28 @ HM

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEPSB 08/08/28 @ HM

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:50  
400  
2:20

M.A 08/09/02

(10x)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 31/07/2008 12:17:55 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40845

Part Number: D2565103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-09-03 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 270

DS 08/09/03

(10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/03 (10)

Job Completion

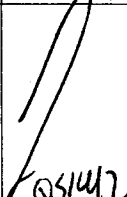
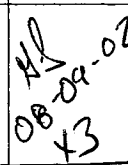
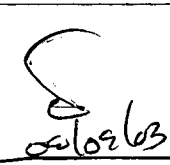
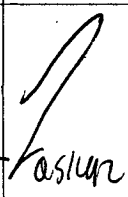
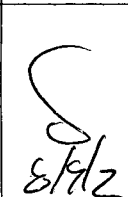
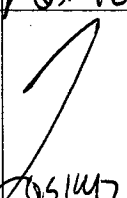
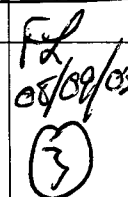
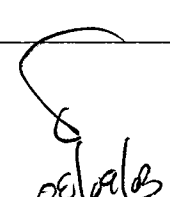
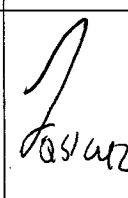
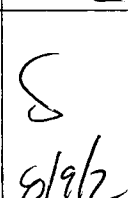


MF 08-09-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2565-103 PAR #: N/A Fault Category: Prod / Finishing NCR: (Yes) No DQA: D Date: 08/09/05  
D205-633 QA: N/C Closed: D Date: 08/09/05

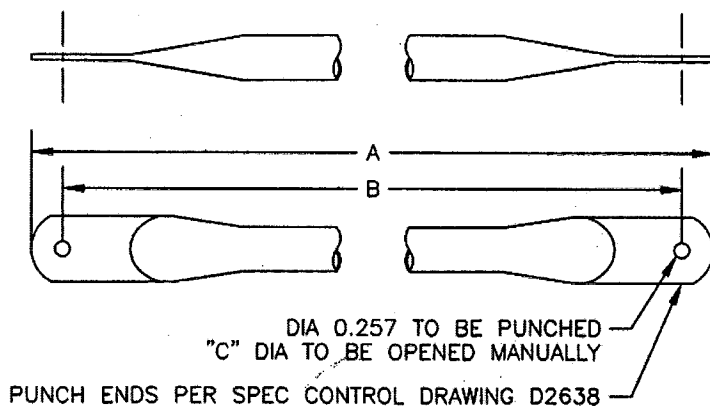
NCR: <u>40845</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/2	6.0	on three struts it was found with ink from the mat. showing through the powder coat. only in small areas		scuff all three with 320 grit sand paper. AND clean with acetone.	 08-09-02 +3	 08/09/03		 8/9/2
				Re powder coat as per QS 7005	 08/09/03 (3)	 08/09/03		 8/9/2

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05				TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE			
B	97.03.15	CORRECT D2565-111 DIM. A			
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)			
D	02.06.05	ADD -3XX PARTS; ADD FINISH			
E	04.05.05	ADD D2565-401-411; RMV ANGLE D			

RELEASED  
04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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